

Ship 18 Awt

Work Order ID 164332

164332

Page 1

Tuesday, July 18, 2017 1:06:09 PM

Item ID: D119-796-025 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-On Landing Wearplates
 Start Date: 8/8/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/29/2017 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan:  Date: JUL 18 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D119-796-025	A
IIN-D119-796	F

100	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

100

Packaging	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Packaging	Photocopy bluefile and create labels as per PPP D119-796-025 chg 003/ D119-646-241 paperwork								
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110	Assemble as per dwg	0.00							
-----	---------------------	------	--	--	--	--	--	--	--

110

HandFinish	Memo	0.00							
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Hand Finishing	ASSEMBLE AS PER DWG AND NOTES 8,9,10,11								
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115 SMALL Fob.

ASSEMBLE WITH PROSEAL BATCH: 137495

2-INSTALL DECAL D2729-4

IX 17/08/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER :									

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164.332

Page 2

Item ID: D119-796-025

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-On Landing Wearplates

Start Date: 8/8/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/29/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

123

Pick Kit

0.00

123

Packaging

Memo

0.00

Packaging

126

QC4- 100% Inspect kits for completeness

0.00

126

QC

Memo

0.00

Quality Control

JUL 18 2017

DAS
6
9-89DAS
16
9-89

17/08/31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130

Identify as per dwg & Stock Location: *Ship*

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-796-025

Location: _____

PPP Rev: _____

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

AUG 31 2017 *uy*DAS
21
9-89

AUG 31 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																													
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Picklist Print

Tuesday, July 18, 2017 1:07:38 PM

Page 1

Work Order ID: 164332

164332

Parent Item: D119-796-025

D119-796-025

Parent Item Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-On Landing Wearplates

Start Date: 8/8/2017

Required Date: 8/29/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.08.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
139x89x35crate		Purchased	No			100	Each	0.0000	1	1			
139x89x35crate									**			17/08/29/17	
Agusta Crate													
D119-646-241		Manufactured	No			100	Each	0.0000	2	2			
D119-646-241									**			17/08/29/17	
AW119 Replacement Skidtube with Heavy Duty Wearplates - Fits LH or RH													
D119-796-151		Manufactured	No			100	Each	0.0000	1	1			
D119-796-151									**			17/08/29/17	
FWD Crosstube Installation with Step (no hardware)													
D119-796-251		Manufactured	No			100	Each	0.0000	1	1			
D119-796-251									**			17/08/29/17	
AFT Crosstube Installation with Step (no hardware)													
D2652		Manufactured	No			100	Each	294.0000	48	48			
D2652									**				
Bushing													

Location

Loc Qty

Loc Code

FG

44

31985

44

ST009

250

161518

250

JUL 18 2017

DAS
6
9-89

Xs

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Parent Item Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-On Landing Wearplates

Start Date: 8/8/2017

Required Date: 8/29/2017

Start Qty: 1.00

Required Qty: 1.00

D3407-041

Manufactured No

100

Each

24.0000

2

2

D3407-041

Tow Ring

**

JUL 18 2017 6 9-89

Location

Loc Qty

Loc Code

st530

24

159443

9

161679

8

162967

6

78878

1

2

D3417-5

Manufactured No

100

Each

57.0000

4

4

D3417-5

Washer

**

JUL 18 2017 6 9-89

Location

Loc Qty

Loc Code

ST034

57

158791

57

4

D3456-1

Manufactured No

100

Each

119.0000

2

2

D3456-1

Washer

**

JUL 18 2017 6 9-89

Location

Loc Qty

Loc Code

FG

5

25701

5

ST036

114

103539

1

159500

17

162291

96

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Page 3

Work Order ID: 164332

164.332

Parent Item: D119-796-025

D119-796-025

Parent Item Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-On Landing Wearplates

Start Date: 8/8/2017

Required Date: 8/29/2017

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured No

100

Each

848.0000

48

48

D3672-3

Washer, Phenolic

**

Location

Loc Qty

Loc Code

FG	100	
133083	52	
134449	48	
FP001	133	
132639	133	
ST047	615	
153292	32	
153930	83	
<u>162576</u>	500	

JUL 18 2017

DAS
6
9-89

D3672-7

Manufactured No

100

Each

559.0000

48

48

D3672-7

Washer, Phenolic

**

Location

Loc Qty

Loc Code

FG	41	
129987	6	
133986	15	
153039	20	
ST047	18	
153039	18	
ST051A	500	
157442	500	

157442

JUL 18 2017

DAS
6
9-89

D3883-1

Manufactured No

100

Each

7.0000

2

2

D3883-1

Saddle, Outboard LH

**

Location

Loc Qty

Loc Code

ST404	7	
153815	1	
<u>161650</u>	6	

2

JUL 18 2017

DAS
6
9-89

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Page 4

Work Order ID: 164332

164332

Parent Item: D119-796-025

D119-796-025

Parent Item Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-On Landing Wearplates

Start Date: 8/8/2017

Required Date: 8/29/2017

Start Qty: 1.00

Required Qty: 1.00

D3883-2 Manufactured No 100 Each 8.0000 2 2

D3883-2

Saddle, Outside RH

**

DAS
6
9-89

JUL 18 2017

Location

Loc Qty

Loc Code

ST404

8

157414

4

162356

4

2

D3884-1

Manufactured No

100 Each

7.0000

2

2

D3884-1

Saddle, Inside LH

**

DAS
6
9-89

JUL 18 2017

Location

Loc Qty

Loc Code

ST404

7

161651

7

2

D3884-2

Manufactured No

100 Each

8.0000

2

2

D3884-2

Saddle, Inside RH

**

DAS
6
9-89

JUL 18 2017

Location

Loc Qty

Loc Code

ST404

8

161652

2

162355

6

2

D3886-041

Manufactured No

100 Each

19.0000

4

4

D3886-041

Lug Assembly

**

DAS
6
9-89

JUL 18 2017

Location

Loc Qty

Loc Code

ST521

8

162597

8

ST528

5

157602

5

ST532A

6

156995

6

4

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

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Work Order ID: 164332

164332

Parent Item: D119-796-025

D119-796-025

Parent Item Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-On Landing Wearplates

Start Date: 8/8/2017

Required Date: 8/29/2017

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Purchased

No

100

Each

395.0000

8

8

AN3C46A

Bolt

**

JUL 18 2017

Location

Loc Qty

Loc Code

CCK007

375

m138009

375

FG

10

122843

10

ST346

10

m136055

4

m136181

6

AN3C50A

Purchased

No

100

Each

230.0000

16

16

AN3C50A

Bolt

**

JUL 18 2017

Location

Loc Qty

Loc Code

OVER002

152

M137074

152

ST346

78

M136503

78

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Work Order ID: 164332

164332

Parent Item: D119-796-025

D119-796-025

Parent Item Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-On Landing Wearplates

Start Date: 8/8/2017

Required Date: 8/29/2017

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

100

Each

240.0000

24

24

AN4C6A

Bolt

**

JUL 18 2017

DAS

6

9-89

DA

BA

9-89

6

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

OVER002

100

m137963

100

ST345

126

m122800

4

m136047

12

m136318

50

m137026

60

24

MS21043-3

Purchased

No

100

Each

1,091.000

24

24

MS21043-3

Nut

**

JUL 18 2017

DAS

6

9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

119

m136182

119

GA

60

m136182

60

ST302

832

m136295

33

m137459

5

m137587

294

m138040

500

24

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
					Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐						

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Work Order ID: 164332

164332

Parent Item: D119-796-025

D119-796-025

Parent Item Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-On Landing Wearplates

Start Date: 8/8/2017

Required Date: 8/29/2017

Start Qty: 1.00

Required Qty: 1.00

MS21043-4 Purchased No 100 Each 729.0000 26 26

MS21043-4

Nut

**

JUL 18 2017

DAS
6
9-89

Location	Loc Qty	Loc Code
FG	40	
104603	40	
GA	99	
m132803	5	
m137371	94	
OVER007	300	
m137886	300	
ST302	290	
m136263	29	
m137361	61	
m137371	200	

136263X3

23

MS21043-5 Purchased No 100 Each 117.0000 8 8

MS21043-5

Nut

**

JUL 18 2017

DAS
6
9-89

Location	Loc Qty	Loc Code
FG	20	
101418	20	
GA	71	
116548	71	
ST302	26	
m137361	26	

8

MS21250-05048 Purchased No 100 Each 50.0000 8 8

MS21250-05048

Bolt (use MS21250-05-048)

**

JUL 18 2017

DAS
6
9-89

Location	Loc Qty	Loc Code
ST295	50	
m135948	50	

8

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

Picklist Print

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Work Order ID: 164332

164332

Parent Item: D119-796-025

D119-796-025

Parent Item Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-On Landing Wearplates

Start Date: 8/8/2017

Required Date: 8/29/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

100

Each

4,640.000

24

24

NAS1149C0332R

WASHER

**

JUL 18 2017

Location

Loc Qty

Loc Code

FP001

264

m137597

264

GA

508

m133284

22

m136444

486

ST260a

3000

m137851

2000

m137951

1000

ST266

868

m135466

66

m137381

802

135466 x 18

6

DAS
6
9-89

NAS1149C0432R

Purchased

No

100

Each

1,159.000

48

48

NAS1149C0432R

WASHER

**

JUL 18 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

341

m134676

341

ST266

818

m136182

32

m137459

786

48

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : _____							

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Work Order ID: 164332

164.332

Parent Item: D119-796-025

D119-796-025

Parent Item Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-On Landing Wearplates

Start Date: 8/8/2017

Required Date: 8/29/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0532R

Purchased

No

100

Each

329.0000

16

16

NAS1149C0532R

WASHER

**

Location

Loc Qty

Loc Code

FP001

84

m135390

8

m136983

76

GA

42

116513

42

ST266

203

m136192

3

m137886

200

MS21920-28

Purchased

No

123

Each

88.0000

2

2

MS21920-28

Clamp

**

Location

Loc Qty

Loc Code

FG

1

105884

1

LG050

79

M137075

4

M137361

25

M137508

25

M137963

25

LG051

1

M132169

1

LG057

2

M134130

2

st543

5

M136740

5

DAS
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9-89

AUG 31 2017

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Tuesday, July 18, 2017 1:07:40 PM

Shop Packet Print

Page 9

DQA: _____ Date: _____

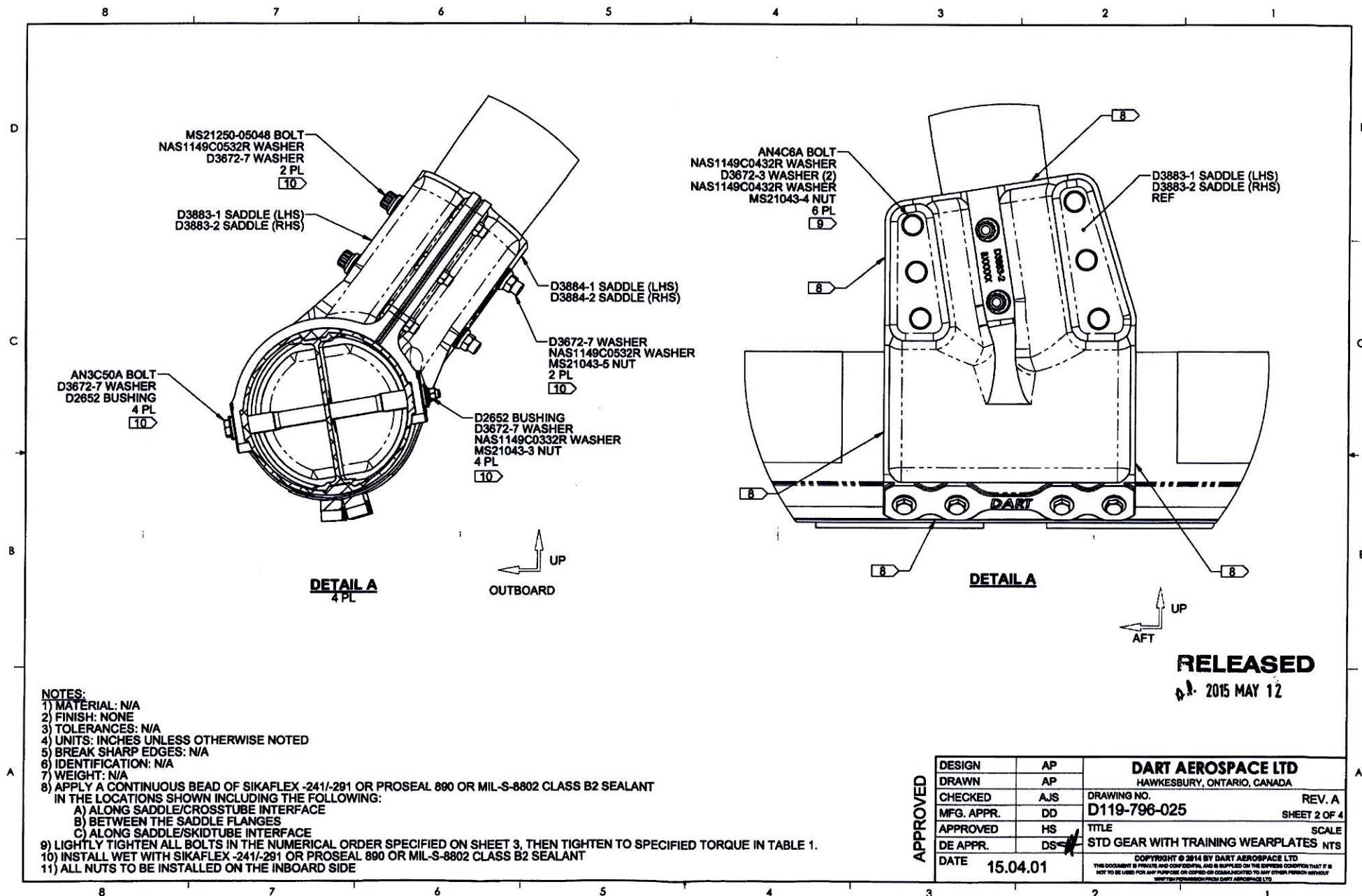
WORK ORDER NON-CONFORMANCE / UPDATE

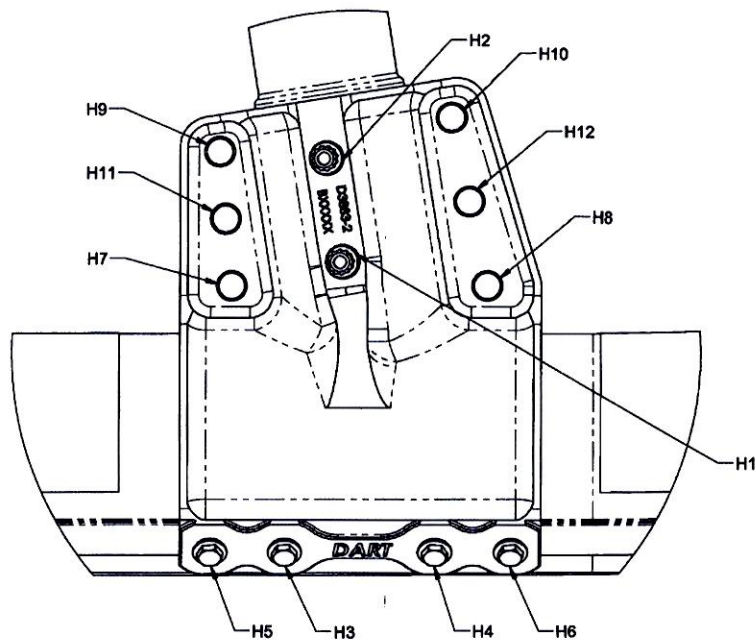


QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
					Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐						





SUPPLEMENTAL VIEW - TORQUE SEQUENCE

TABLE 1: TORQUE SEQUENCE AND MAX TORQUE

TORQUE SEQUENCE	PART NUMBER	TORQUE
H1	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H2	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H3	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H4	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H5	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H6	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H7	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H8	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H9	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H10	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H11	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H12	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)

RELEASED

P.R. 2015 MAY 12

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-025	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH TRAINING WEARPLATES	NTS
DATE	15.04.01	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

D3407-041 TOW RING
D3417-5 WASHER

9

INBOARD

D3417-5 WASHER
D3456-1 WASHER
MS21043-4 NUT

8 9 11

DETAIL C
2 PL

D2652 BUSHING
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

8 9 10

D3886-041 LUG ASSEMBLY

9

INBOARD

D2652 BUSHING
AN3C46A BOLT
2 PL

8 9 10

DETAIL B
4 PL

RELEASED

P.O. 2015 MAY 12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 9) APPLY FAY SEAL AND FILLET SEAL USING SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 10) TORQUE AN3 HARDWARE TO 20-25 IN-LBS
- 11) TORQUE AN4 HARDWARE TO 50-70 IN-LBS

APPROVED

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DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-025	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
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